

Date: Thursday, 2/14/2008 2:21:09 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 37453	
Estimate Number : 10725	
P.O. Number :	Part Number : D2652
This Issue : 2/14/2008 S.O. No. :	Drawing Number : D2652 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 37366	Material :
Written By : <u> </u>	Due Date : 3/15/2008 Qty: <u>264</u> Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:B 02.06.13 Now machined in house. NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0500	303 Round Bar 0.500"
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Comment: Qty.: 0.0578 f(s)/Unit Total : 11.5500 f(s)

Material: 303 ss .500" Round Bar
 (M303R0500)

Batch: M107021 (10.0)

M106996 (5.2592)

B.A

08/02/17

264

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652

FOLIO REV: A
 DWG REV: A

2-DEBURR AS REQUIRED

B.A / ml

08/02/17

264

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B.A / ml

08/02/17

264

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

B.A 08-02-18

264

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST40

AS 08/02/19

x264

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 37453

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



264

Comment: FINAL INSPECTION/W/O RELEASE

08/02/20

Job Completion



2008/2/19

264

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37453
Description: Bushing		Part Number:	D2652
Inspection Dwg: D2652	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

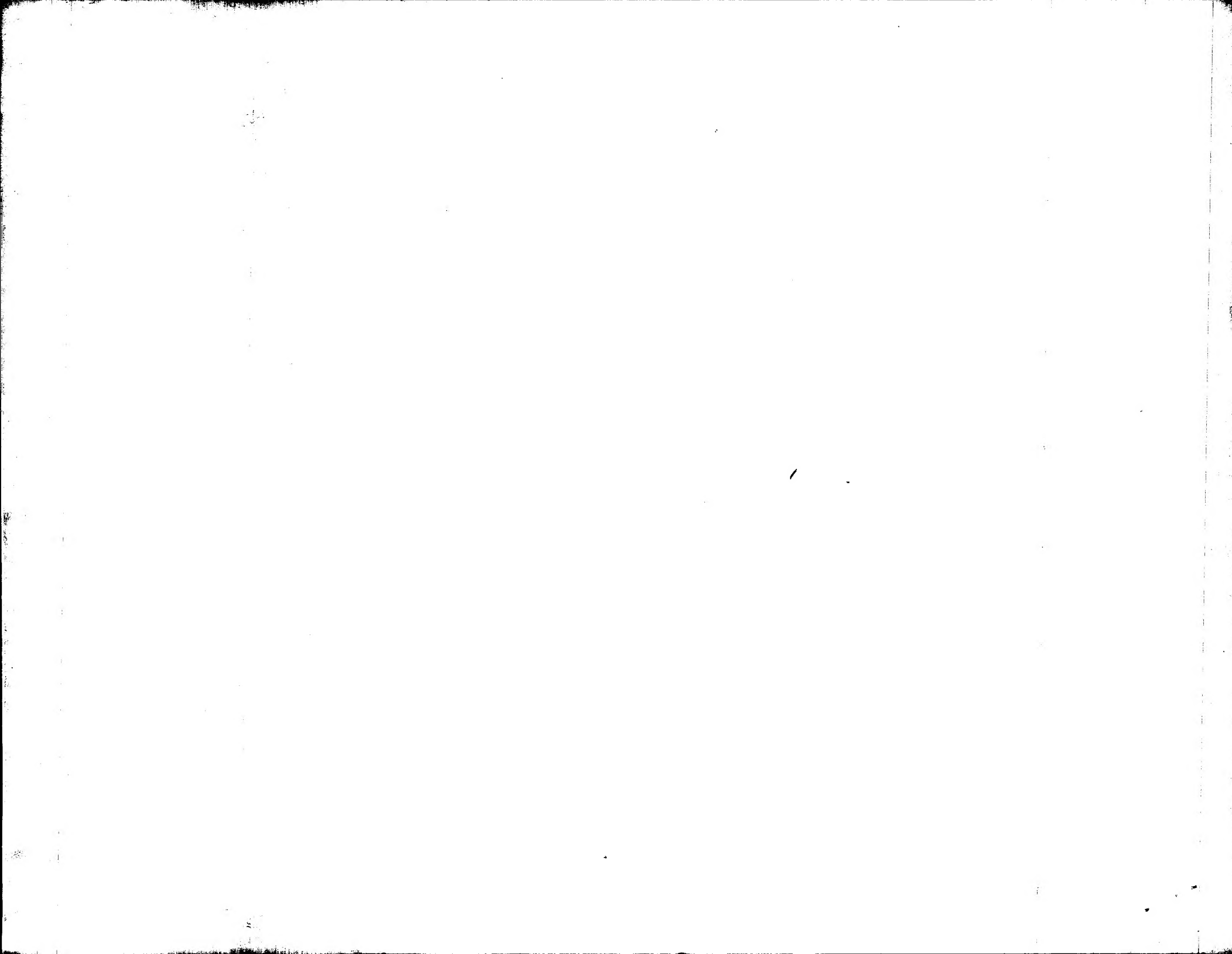
x

Prototype

[illegible]

Measured by:	<i>Y.A./ml</i>	Audited by:	<i>BC</i>	Prototype Approval:	N/A
Date:	<i>08/02/17</i>	Date:	<i>08.02.17</i>	Date:	

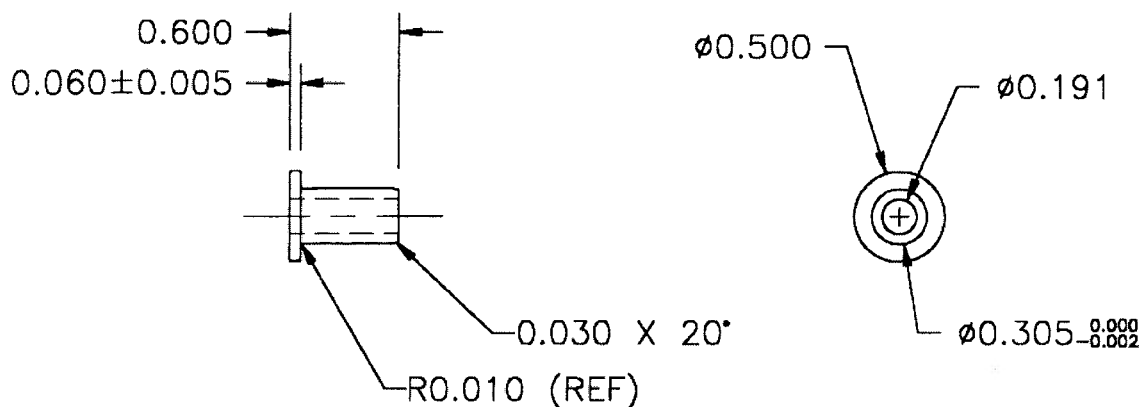
Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37453

MATERIAL: AISI 303 SS
NOTE: BREAK ALL SHARP CORNERS 0.010 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED